

Fig.7

material



roll-forming (a series of 15 to 20 rolls)



5

cutting



flash butt welding



10

correction in roundness



finishing the welded part (5 to 6 steps)



polishing the whole circumference



15

making holes



surface treatment

20

Fig. 1(a)

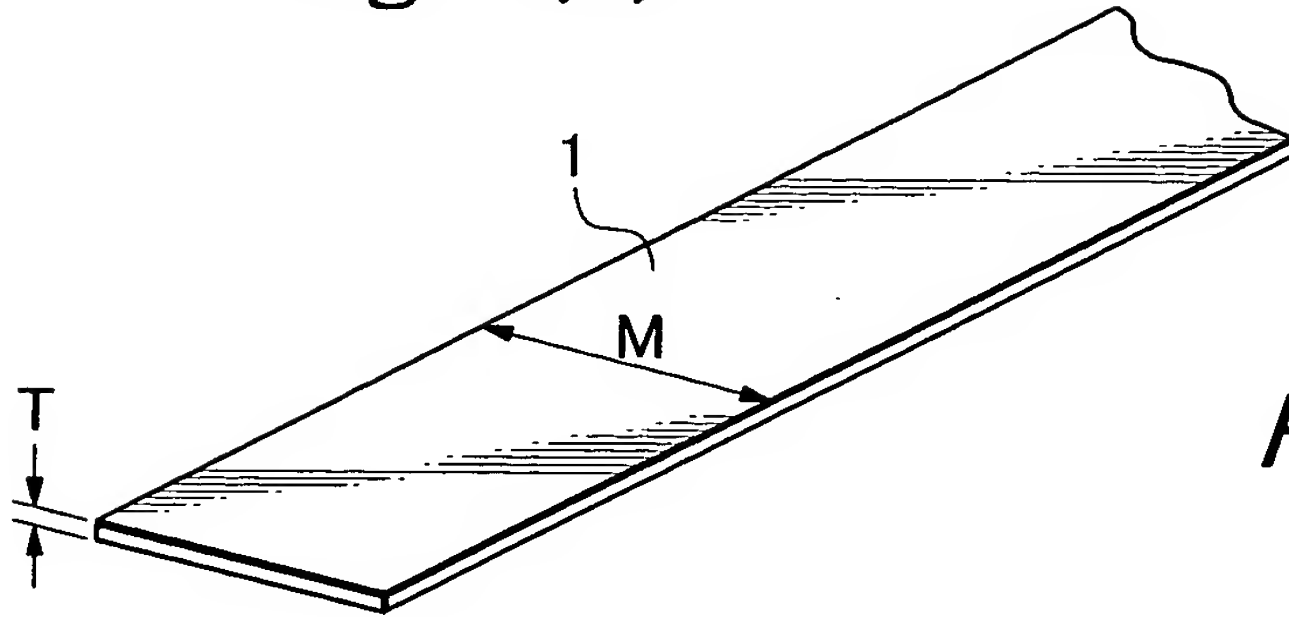


Fig. 1(b)

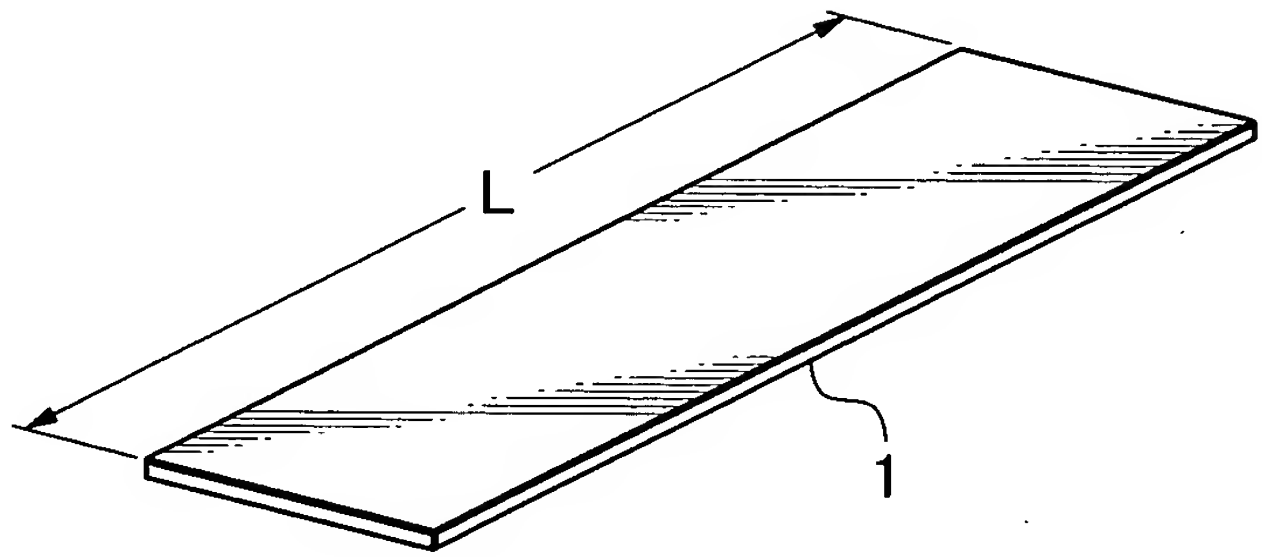


Fig. 1(c)

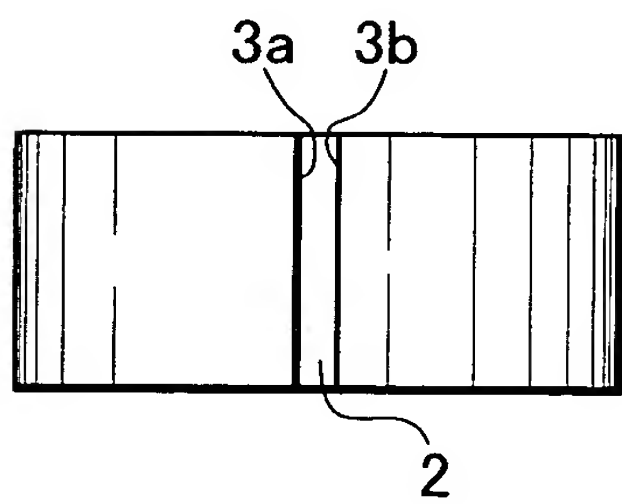


Fig. 1(e)

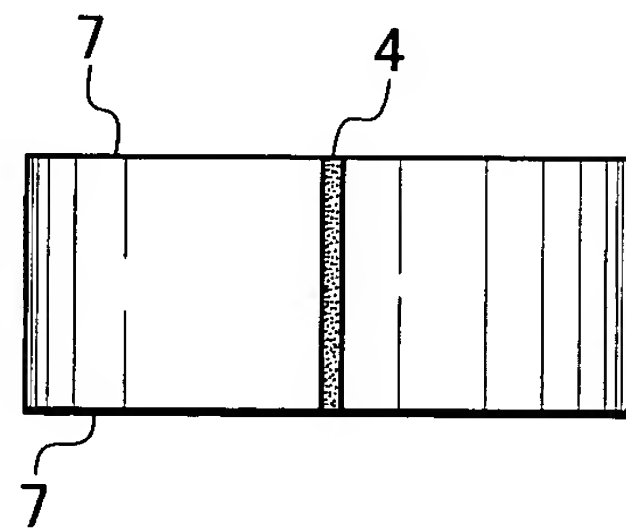


Fig. 1(d)

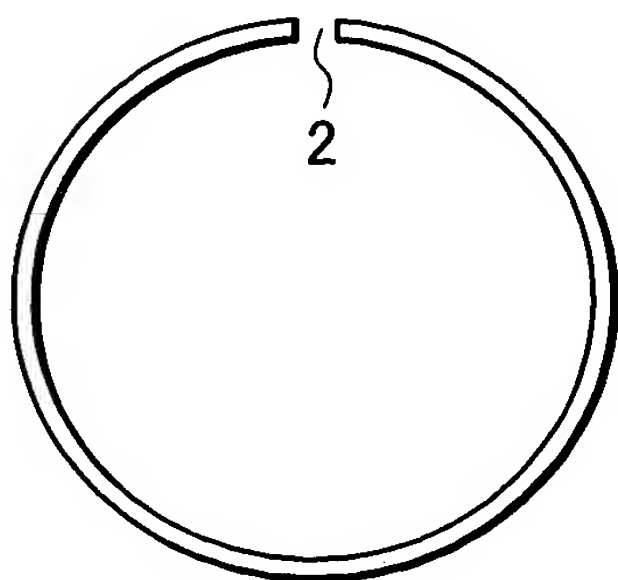


Fig. 1(f)

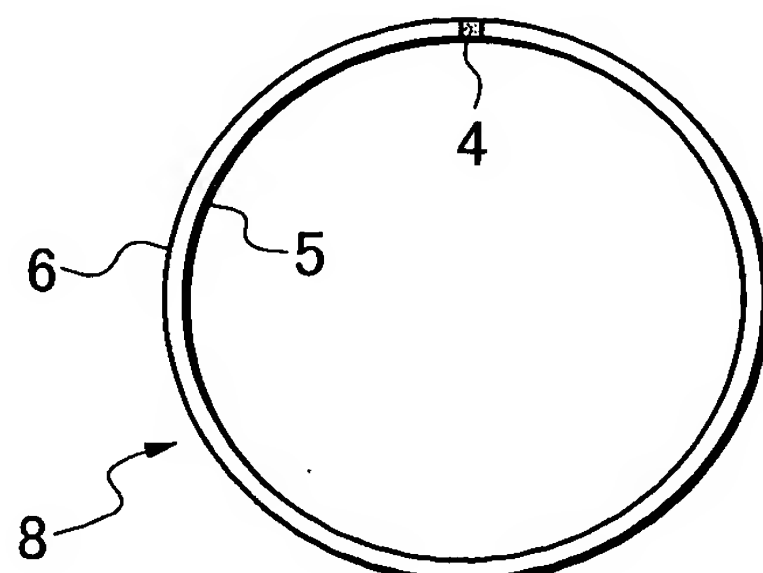


Fig. 2(a)

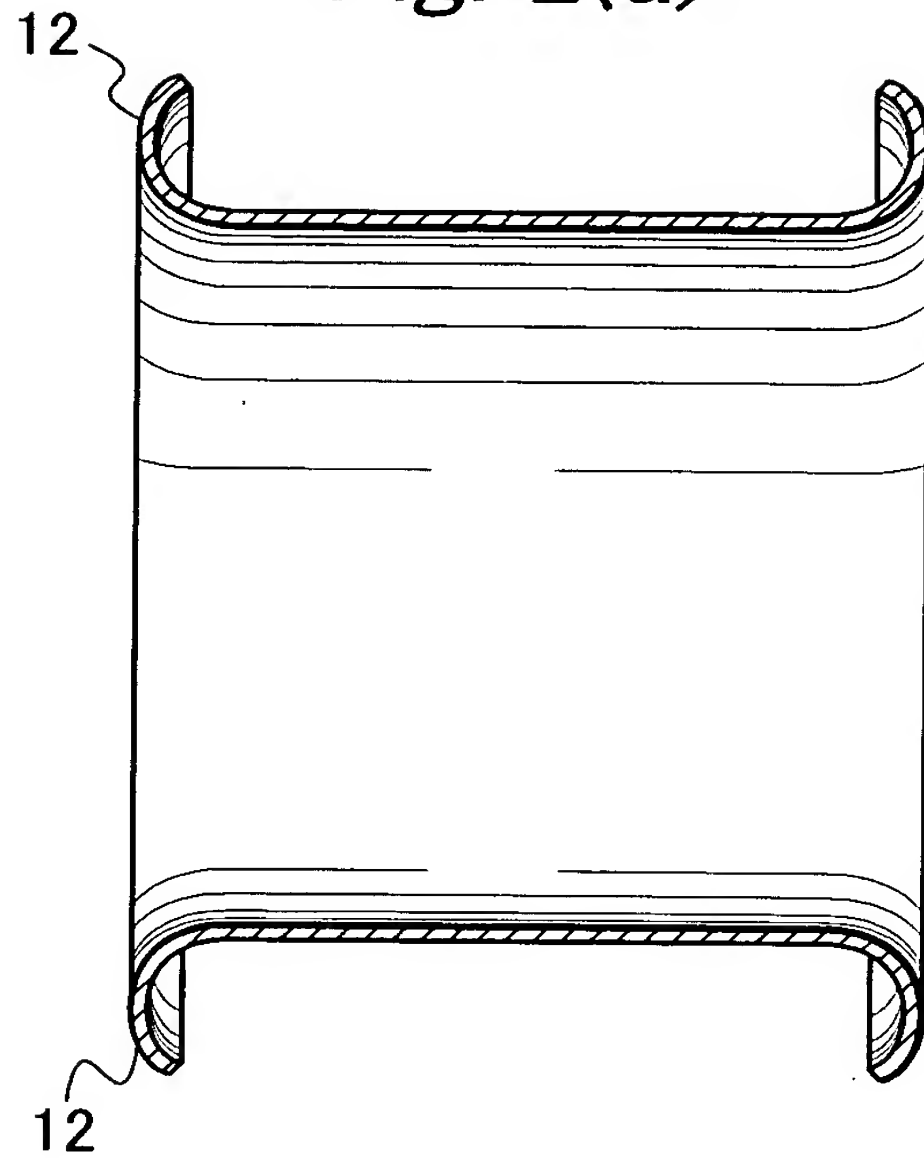


Fig. 2(b)

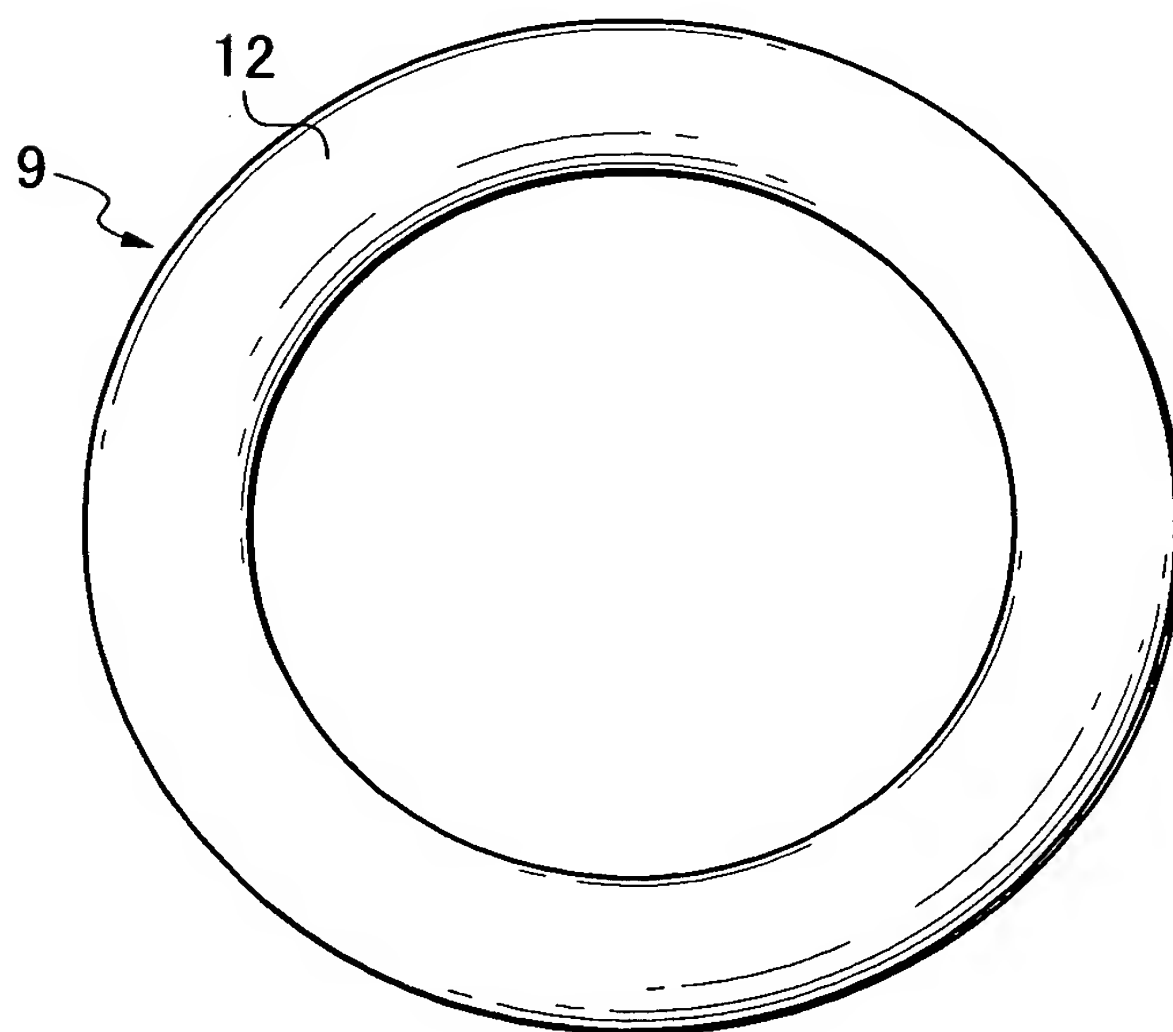


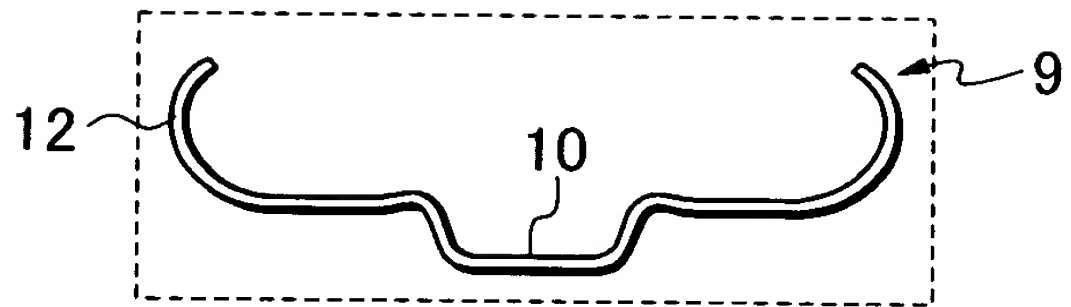
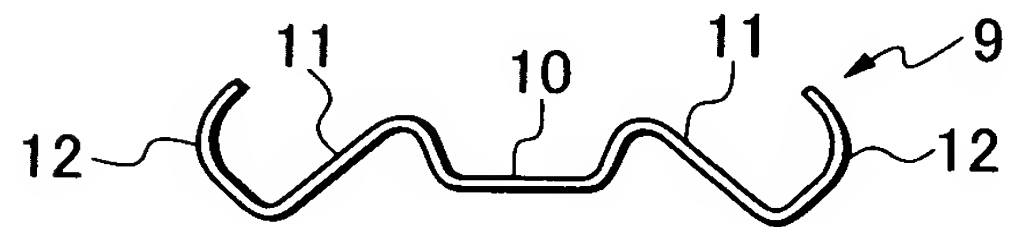
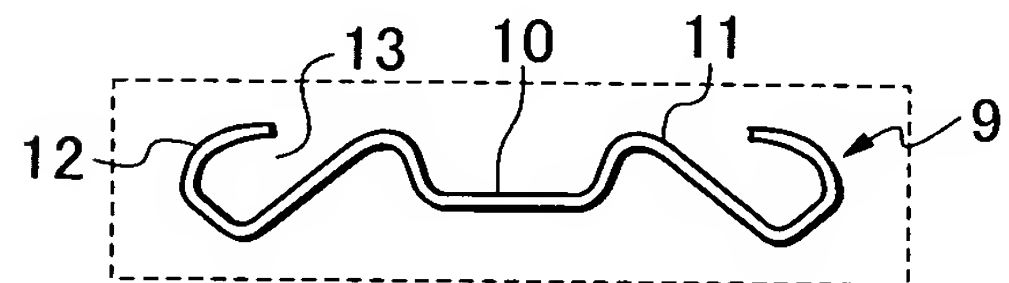
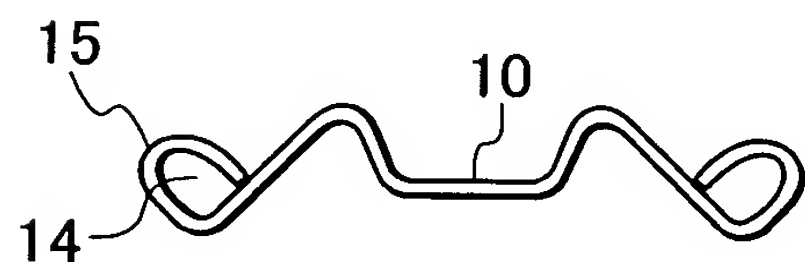
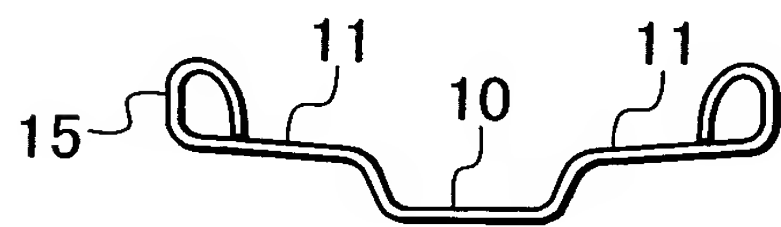
Fig. 3(a)*Fig. 3(b)**Fig. 3(c)**Fig. 3(d)**Fig. 3(e)*

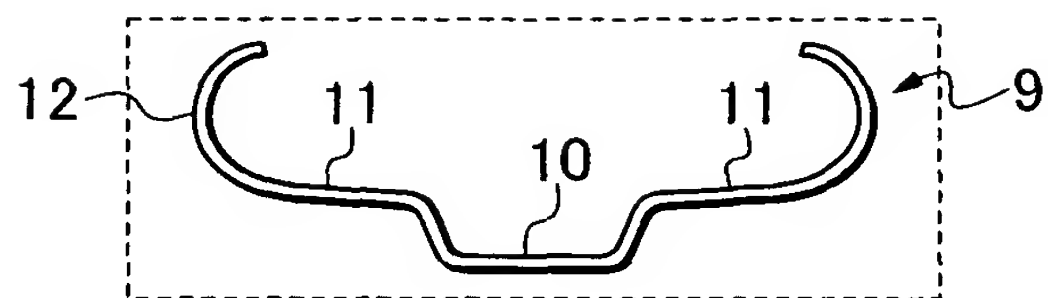
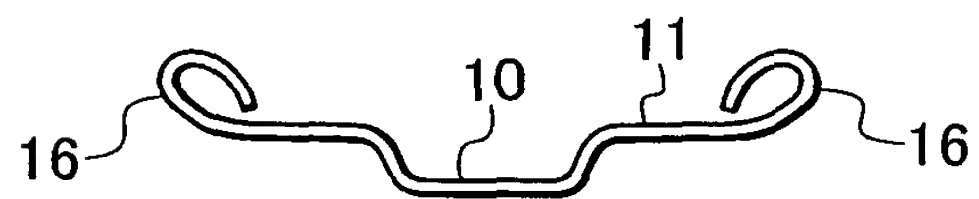
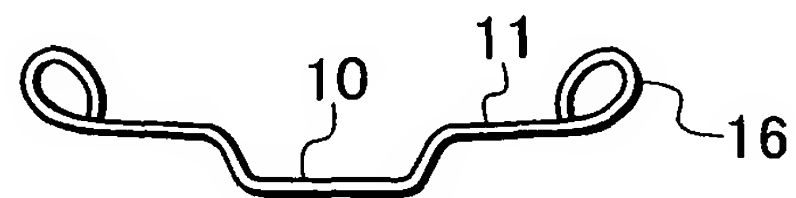
Fig. 4(a)*Fig. 4(b)**Fig. 4(c)*

Fig. 5(a)

PRIOR ART



Fig. 5(b)

PRIOR ART

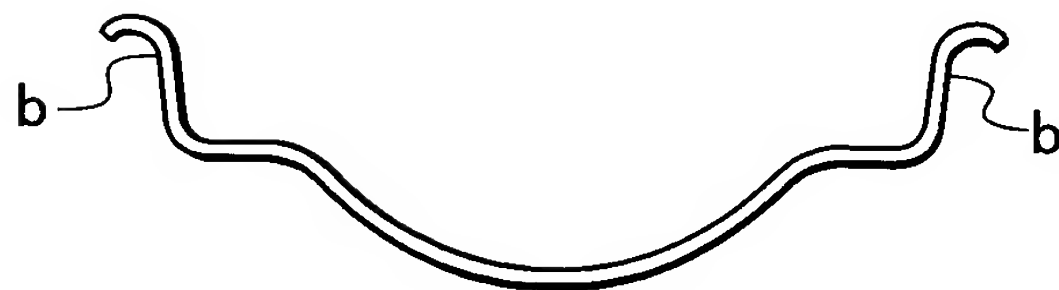


Fig. 6

PRIOR ART

